

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Monday, March 16, 2015 11:08:53 AM

130555

Page 2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Floor Protector, Fwd LH, (Clear)

Stop *NS2*

Start Date: 3/16/2015 **Start Qty:** 2.00

2

Cust Item ID:

Required Date: 3/16/2015 **Req'd Qty:** 2.00

?

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4941 and Folio FTA 158

Dwg. Rev. 2
Folio Rev. 2

130

0.00

130

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

OC

Memo

0.00

Quality Control

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Training									
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Unapproved									

FAULT CATEGORY

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130555

Page 3

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N900040100

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Revision ID:

Item Name: Floor Protector, Fwd LH, (Clear)

Stop *NS2*

Start Date: 3/16/2015 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 3/16/2015 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

[illegible]

160			0.00	
160	Packaging			
Packaging		Memo	0.00	
Packaging				
Packaging				

170	QC21- Final Inspection - Work Order Release	0.00	
170			
QC	Memo	0.00	<u>ML5</u> <u>1504-18</u>
Quality Control			

MF
15-4-17

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Picklist Print

Monday, March 16, 2015 11:08:56 AM

Page 1

Work Order ID: 130555

130555

Parent Item: D4941-1L08

D4941-1L08

Parent Item Name: Floor Protector, Fwd LH, (Clear)

Start Date: 3/16/2015

Required Date: 3/16/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 13/12/16 DL
Revised dimensions 14/02/12 DL
14/07/02 DL

IPP Rev. B
IPP Rev C Revised Dwg.
IPP Rev D Revised Dwg. 14/07/25 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MLEXS.118-90318-08

Purchased

No

100

sf

1,611.000

4.875

10

MI FXS 118-90318-08

**

Lexan Sheet

Location

Loc Qty

Loc Code

therm

1611

m126994

1611

15/04/08

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DART AEROSPACE LTD		Work Order: 130555
Description: FLOOR PROTECTOR		Part Number: D4941-1L08
Inspection Dwg: D4941	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: JS

Date: 15/04/08

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.0	.100	2.01	✓		DL-02	
0.8	.100	0.83	✓		DL-02	
0.4	.100	0.43	✓		DL-02	
20.1	.100	20.125	✓		TH 05	
20.9	.100	20.875	✓		TH 05	
.070	Min .059	.089	✓		TH DI	
.030	Min	.068	✓		TH DI	

Measured by: JS

Date: 15/04/08

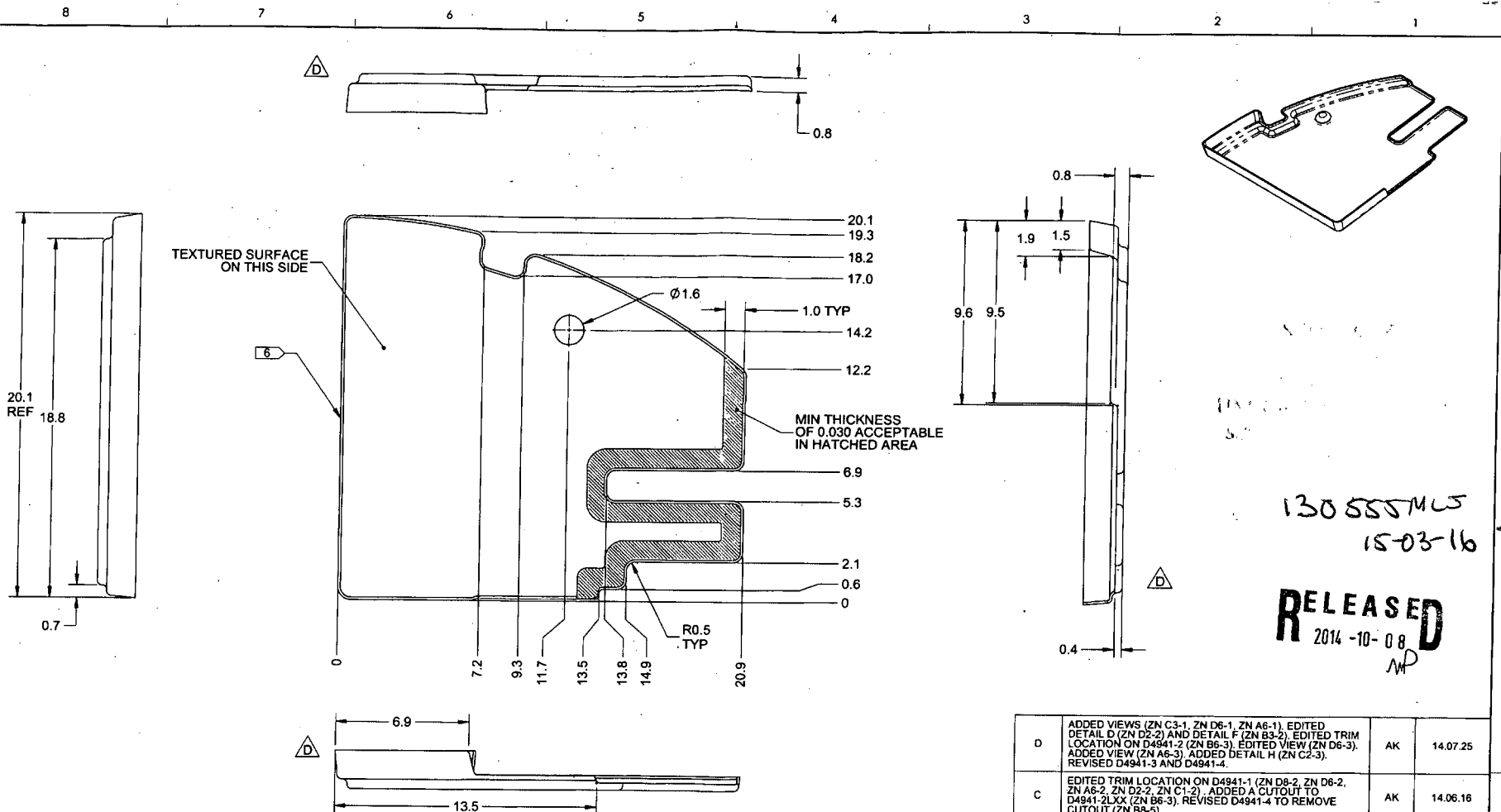
Audited by: SK
38

Date: APR 13 2015

Preliminary Approval: 3-69

Date: _____

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	



D4941-1LXX FWD LH FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4
- 7) WEIGHT: 1.5 lbs
- 8) THERMOFORM PER QSI 022 USING MOLD DT9990
TRIM PER MOLD LEAVING FINISHED EDGES
- 9) MINIMUM THICKNESS AFTER FORMING IS 0.070"

PART NUMBER	DESCRIPTION
D4941-1L02	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.125 THICK (REF DART SPEC MLEXS.125-F6006-02)
D4941-1L08	90318 PROTECT-A-GLAZE 112 CLEAR LEXAN SHEET 0.118 THICK (REF DART SPEC MLEXS.118-90318-08)

D	ADDED VIEWS (ZN C3-1, ZN D6-1, ZN A6-1), EDITED DETAIL D (ZN D2-2) AND DETAIL F (ZN B3-2), EDITED TRIM LOCATION ON D4941-2 (ZN B6-3), EDITED VIEW (ZN D6-3), ADDED VIEW (ZN A6-3), ADDED DETAIL H (ZN C2-3), REVISED D4941-3 AND D4941-4.	AK	14.07.25
C	EDITED TRIM LOCATION ON D4941-1 (ZN D8-2, ZN D6-2, ZN A6-2, ZN D2-2, ZN C1-2), ADDED A CUTOUT TO D4941-2LXX (ZN B6-3), REVISED D4941-4 TO REMOVE CUTOUT (ZN B8-5).	AK	14.06.16
B	REVISED OVERALL DIMENSIONS OF D4941-1/2/3/4	AK	14.02.12
A	NEW ISSUE	AK	13.10.03
REV.	DESCRIPTION	BY	DATE
DESIGN	AK	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4941 REV. D SHEET 1 OF 5 TITLE CABIN FLOOR PROTECTORS SCALE NTS COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AK		
CHECKED	VS		
MFG. APPR.	DL		
APPROVED	HS		
DE APPR.	DS	DATE 14.07.25	

